

**Amendments To The Specification**

Please replace the paragraph in lines 2 to 4 on page 1 with the following amended paragraph:

The present invention relates to a process for manufacturing a film-type packaging material, a device for carrying out the process and the use of the packaging material.

Please replace the paragraph in lines 6 to 8 on page 1 with the following amended paragraph:

Various forms of packaging with sealing seam closures are widely used as the production of such closures is extremely simple and ~~cost-favourable~~ cost-favorable, and, e.g., in many cases meet the requirements of one-way packaging.

Please replace the paragraph in lines 20 to 25 on page 1 with the following amended paragraph:

The sealing coatings are, e.g., cold-sealing or hot sealing lacquers. Cold-sealing lacquers are normally have a latex-base and are employed especially for heat-sensitive goods. Hot-sealing lacquers which are adhesives that can be activated thermally are, e.g., in the form of polymers. They are, as a rule, deposited on the packaging material in the form of solutions (lacquers) or in the form of films of a polymeric material.

Please replace the paragraph on page 1, line 27, to page 2, line 2, with the following amended paragraph:

The conventional production methods suffer the disadvantage ~~hat~~ that the sealing layers or sealing lacquer layers can be deposited only over the whole surface or only to a limited extent over part of the surface. Further, setting up the production facilities for ~~localised~~ localized deposition of the sealing layer is complicated, therefore, local deposition can not simply be changed at will. Further, solvent containing lacquers are not completely free of problems from the environmental standpoint and should, therefore, be replaced by solvent-free coating systems.

Please replace the paragraph in lines 4 to 7 on page 2 with the following amended paragraph:

The object of the present invention is, therefore, to propose a manufacturing process and a device which enable ~~localised~~ localized deposition of sealing lacquer layers or sealing layers whereby the pattern of locally deposited sealing layer can be changed without excessive cost or expenditure of time.

Please replace the paragraph in lines 22 to 29 on page 2 with the following amended paragraph:

The powder particles or the powder lacquer particles preferably comprise or contain thermoplastic polymer which can be melted. The powder particles or powder lacquer particles may also be tribo-modified, i.e., the particles contain

additives which enable the particles to be highly electrostatically charged by means of friction. The powder particles or powder lacquer particles may also contain additives, such as, filler materials, pigments, antioxidants or ~~stabilisers~~ stabilizers and further functional additives. The use of powder particles or powder lacquer particles enables solvent-free coating systems to be employed.

Please replace the paragraph in lines 24 to 28 on page 3 with the following amended paragraph:

The ~~localised~~ localized deposition of the sealing layer is performed preferably by means of an electrophotographic process. To that end, the sealing station preferably contains means for electronic data processing which permits specific partial-area, i.e., ~~localised~~ localized depositon of the sealing layer on the basis of a printer's copy, i.e., printer's copy.

Please replace the paragraph on page 3, line 30, to page 4, line 1, with the following amended paragraph:

The sealing station may also contain means which can monitor the thickness of the layer to be deposited and/or regulate the same. The regulation of the thickness of the layer or ~~localised~~ localized layer to be deposited is performed preferably by means of digital printing technology.

Please replace the paragraph in lines 3 to 7 on page 4 with the following amended paragraph:

The local deposition of a layer is usefully based on the printer's copy which reproduces the arrangement of the area to be sealed. The data for the

printer's copy are preferably available in digital form and are, e.g., created or reworked e.g. by desktop-publishing means, i.e., by means of ~~programmes~~ programs for image processing or the like involving equipment for electronic data processing (EDP).

Please replace the paragraph in lines 9 to 16 on page 4 with the following amended paragraph:

The data may be stored, e.g., on a magnetic, magneto-optical or optical storage medium. It is also possible to store electronically a printer's copy which is in analogue data form using appropriate ~~means~~ means, such as, EDP equipment and data processing ~~programmes~~ programs (e.g. scanner equipment), and to transform this into digital signals and process this further by means of an analogue-digital transformer. The data of the printer's copy present in digital form are usefully reproduced via an electrophotographic process in the form of the above partial area deposition of a layer on the film or film-type laminate.

Please replace the paragraph in lines 18 to 20 on page 4 with the following amended paragraph:

By digital processing, via appropriate data processing ~~programmes~~ programs, the printer's copy may be worked over and altered with the aid of EDP in an almost unlimited manner.

Please replace the paragraph in lines 22 to 24 on page 4 with the following amended paragraph:

The thickness of the sealing layer is, e.g., 7 – 100  $\mu\text{m}$ , in particular 10 – 50  $\mu\text{m}$ . The sealing layers may be deposited on one or both free surfaces ~~or~~ of the film or film composite.

Please replace the paragraph in lines 3 to 8 on page 5 with the following amended paragraph:

The sealing layer station preferably contains a coating unit in which the sealing layer is deposited locally on the film or film-type laminate using the so-called electrostatic process and, downstream of the coating unit, a heating unit in which the coating, in particular powder lacquer coating, is heated and melted to give a uniform sealing film that adheres to the film surface, and subsequently is solidified by cooling.

Please replace the paragraph in lines 10 to 15 on page 5 with the following amended paragraph:

The film-type laminate manufactured according to the invention may be manufactured as a monofilm or a multi-layer film or film-type laminate. The films may be, e.g., of metal (metal foils, thin metal layers), paper, plastic or a combination thereof. The film laminate may contain layers of material out of paper, metal or plastic. Examples of metal foils as packaging materials are foils of iron, steel, copper and preferably ~~aluminium~~ aluminum and its alloys.

Please replace the paragraph in lines 17 to 21 on page 5 with the following amended paragraph:

If the sealing lacquer layer is deposited locally, i.e., over only part of an ~~aluminium~~ aluminum foil, care should be taken that, at least those areas of the aluminum ~~aluminium~~ foil which are not covered by the sealing lacquer coating, are coated with a pre-treatment layer, preferably a pre-treatment layer of a polymer, such as a pre-lacquer coating, in order to avoid corrosion arising from rubbing.

Please replace the paragraph in lines 6 to 8 on page 6 with the following amended paragraph:

The production device is ~~characterised~~ characterized in that the sealing layer station contains means for coating the films or film-type laminate using an electrostatic coating process.

Please replace the paragraph from line 28 on page 6 to line 9 on page 7 with the following amended paragraph::

The transfer of the coating particles to the film surface is carried out preferably by means of a process employing ~~so-called~~ so-called EMB-Technology (Electro-Magnetic Brush Technology) such as is employed in particular in two-component developer systems. Here, a ~~so-called~~ so-called carrier is employed in the form of ferromagnetic particles, whereby the coating particles are attached to the carrier by tribo-electrical forces. The developer system, comprising the carrier and the coating particles adhering to them, is

deposited over a rotating magnet roll facing the transfer roll or transfer belt. As a result of the magnetic forces acting between the magnet roll and the carrier, the developer system is drawn in a chain-like manner to the magnet roll and forms a brush-like arrangement, also known as magnet brush. The magnet brush strokes the transfer roll and creates a ~~so-called~~ so-called brush effect as a result of which the coating particles are transferred, with the aid of electrostatic forces, to the electrostatically charged surface of the transfer roll.

Please replace the paragraph in lines 12 to 14 on page 8 with the following amended paragraph:

The image processing means preferably comprise means for electronic data processing (EDP) – in particular, image processing programs programmes for creating printer's copies, The printer's copy is preferably in digital form.

Please replace the paragraph in lines 16 to 22 on page 8 with the following amended paragraph:

The flexible packaging material manufactured according to the invention is preferably employed for the production of sealable forms of packaging, in particular pouch-type packaging such as flat pouches, flat-bottom bag bags pouches, standing pouches, large and small bags, cushion-type packs, and sacks. Further, the film-type laminate may also be employed to manufacture supports for goods, boxes, base parts for push-through packs, blister packs or lid materials for containers or supports for goods.

Please replace the paragraph in lines 24 to 32 on page 8 with the following amended paragraph:

The flexible packaging material manufactured by the process according to the invention may also be a lid-film (~~Push-through~~ push-through film or peelable film) of a blister pack. To advantage, the push-through film contains a foil of ~~aluminium~~ aluminum or an ~~aluminium~~ aluminum alloy, hereinafter – for simplicity – ~~aluminium~~ aluminum foil. The push-through film may be an ~~aluminium~~ aluminum foil in hard or soft condition. The ~~aluminium~~ aluminum foil may be, e.g., ~~aluminium~~ aluminum of a purity level of 98.6% or higher. Further, the ~~aluminium~~ aluminum foil may be of an ~~aluminium~~ aluminum alloy of the AA 8XXX type, such as AA 8014, or AA 8079. The ~~aluminium~~ aluminum foil may, e.g., have a thickness of 10 to 100  $\mu\text{m}$ , in particular, 15 to 50  $\mu\text{m}$ .

Please replace the paragraph in lines 1 to 7 on page 9 with the following amended paragraph:

The ~~aluminium~~ aluminum foil of the said push-through film contains on its inner lying side, i.e. on the side facing the contents, a hot-sealing layer deposited by the process according to the invention. The hot-sealing layer may, e.g., be of a PVC (polyvinylchloride) or of a poly-blend (mixture) of PVC and another polymer. The hot-sealing layer may also be a copolymer of PVC, in particular a copolymer of PVC with an acrylic resin. Other additives, such as, methylacetate and/or butyl-acetate, may be added to the said copolymer.



Please replace the paragraph in lines 9 to 13 on page 9 with the following amended paragraph:

In order to avoid corrosion due to rubbing, at least those areas of the aluminum ~~aluminium~~ foil that are not covered with the sealing layer are preferably provided with a pre-treatment layer of a polymer such as a pre-lacquer. The pre-treatment layer may also be deposited over the whole surface area of the ~~aluminium~~ aluminum foil, whereby in that case the sealing layer is situated on the pre-treatment layer.

Please replace the paragraph in lines 15 to 17 on page 9 with the following amended paragraph:

A covering pre-treatment layer of the ~~above-mentioned~~ above-mentioned kind is also foreseen when the sealing layer is of pure PVC, as this is known to bond unsatisfactorily to an ~~aluminium~~ aluminum surface.

Please replace the paragraph in lines 19 to 24 on page 9 with the following amended paragraph:

The outer lying side of the ~~aluminium~~ aluminum foil, i.e., the side facing away from the contents of the packaging, preferably contains a pre-treatment layer, e.g., in the form of a polymer or a lacquer, and printing on top of that. Instead of a pre-treatment layer, the outer side of the ~~aluminium~~ aluminum foil may also feature a plastic film and the printing on top of the plastic film. If desired, a protective lacquer coating or print overlayer may be provided on top of the printing.

Please replace the paragraph in lines 22 to 26 on page 10 with the following amended paragraph:

The deposition of the hot-sealing layer 14 at the sealing layer station 4 is carried out using an electrophotographic process. Each sealing layer 4 also has a heating unit (not shown here) associated with it in which the hot-sealing layer 14 is melted to form a sealing film that adheres to the substrate film surface and subsequently is solidified.